

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-009404**Date Inspected:** 15-Sep-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Lv Liaing**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Hiranch Patel, was present during the times noted above for observations relative to the work being performed.

ESD1 Lift-1, ZPMC Dock

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The member is identified as OBG Components. The weld designations reviewed are as follows:

-(ESD1-SA233E/F-3,4)- REJECT, Found two relevant indications.

-(ESD1-SA227G/H-3,4)

This QA inspector observed the following work in progress:

Segment 8AE

FCAW welding of weld joint SSD18-PP064-033~070 located on Segment 8AE. Welder is identified as 066683(3G). ZPMC QC-CWI is identified as Wang Xiang Pin. The welding variables recorded by QC appeared to comply with the Applicable WPS.

FCAW welding of weld joint SSD16-PP062-032~069 located on Segment 8AE. Welder is identified as 066683(3G). ZPMC QC-CWI is identified as Wang Xiang Pin. The welding variables recorded by QC appeared to comply with the Applicable WPS.

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SMAW welding of weld joint SSD13-PP085-131 located on Segment9EW. Welder is identified as 047864 (4G). ZPMC QC-CWI is identified as Li Ming Yang. The welding variables recorded by QC appeared to comply with the Applicable WPS.

FCAW welding of weld joint SSD13-PP089-135, 129, 130 located on Segment10BW. Welder is identified as 202122 (3G/3F). ZPMC QC-CWI is identified as Li Ming Yang. The welding variables recorded by QC appeared to comply with the Applicable WPS.

FCAW welding of weld joint SSD13A-PP089-135, 129, 126 located on Segment10BW. Welder is identified as 047866 (3G/3F). ZPMC QC-CWI is identified as Li Ming Yang. The welding variables recorded by QC appeared to comply with the Applicable WPS.

SAW welding of weld joint Seg071A-001 located on Segment11DW. Welder is identified as 058100 (1G). ZPMC QC-CWI is identified as Zhang Xian Ji. The welding variables recorded by QC appeared to comply with the Applicable WPS.

FCAW welding of weld joint Seg072A-001 located on Segment11DW. Welder is identified as 0458038 (1G). ZPMC QC-CWI is identified as Zhang Xian Ji. The welding variables recorded by QC appeared to comply with the Applicable WPS.

FCAW welding of weld joint SSD13A-PP089-065~104 located on Segment10BW. Welder is identified as 202122/047866 (3F). ZPMC QC-CWI is identified as Xu Tao. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Unless otherwise noted, all observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

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| Inspected By: | Patel,Hiranch | Quality Assurance Inspector |
| Reviewed By: | Patterson,Rodney | QA Reviewer |
